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Hawkesbury, ON
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Canada

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D117-762-041
Job Sheet 201678



Part No: D117-762-041

Job Qty: 1 pcs

Part Name: Replacement Skid Tube

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/8/19

Job Tracking No:

Due Date: 10/29/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3582 REV E IPP Rev:A 07.06.11 New Issue EC IPP Rev:B 08-02-22 change to revA as per dwg DD verF by:EC IPP REV:C 15.06.11 AS PER CHG002 DD VERF:JLM IPP REV:D 16.02.05 DWG REV:C (ecn16-514)DD VERF:JLM IPP REV:E 17.01.17 as per dwg REV:D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
130	Skidtubes - 1	1 pcs		10/29/19	0.00	3.30	Skidtubes - 1		DD
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
140	Skidtubes - 2 - B4B	1 pcs		10/29/19	0.00	3.30	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		BF
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
150	QC 10	1 pcs		10/29/19	0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
							QC 10 - 68		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		

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9-89

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[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	DA ⁵
					QC 5 - 68	NOV 06 2019 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
170	Handfinish - 1-1 Chemical-B4B	1 pcs	10/29/19	0.00 0.97	Handfinish - 1 - 1 - B4B	BEB/9-11-06
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
180	QC 7	1 pcs	10/29/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	

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					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
190 Skidtubes - 3 - B4B	1	10/29/19	0.00 3.33		Skidtubes - 1 - B4B	DB
pcs					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	BE
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
200 QC 10	1	10/29/19	0.00 0.00		QC 10 - 10	
pcs					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
					QC 10 - 68	DAS
210 QC 5	1	10/29/19	0.00 0.00		QC 5 - 10	NOV 11 2019 68
pcs					QC 5 - 12	9-89
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS
					QC 5 - 9	NOV 11 2019 68
					QC 5 - 50	9-89
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
215 Handfinish - 2-1 Pressure-	1	10/29/19	0.00 0.97		Handfinish - 2 - 1 -	BE 819-11-11

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B4B	pcs					B4B	
						Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	
						Handfinish - 2 - 4 - B4B	
220 Powdercoat - 1 White GI(A)- B4B	1 pcs	10/29/19	0.00	0.26		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	ML 19-11-14
						Powdercoat - 4 - B4B	
230 QC 3	1 pcs	10/29/19	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	ML 19-11-14
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
250 Handfinish - 4-1-Assembly- B4B	1 pcs	10/29/19	0.00	0.97		Handfinish - 4 - 1 - B4B	ML 19-11-14
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	

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260 QC 5	1 pcs	10/29/19	0.00 0.00	Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
270 Packaging 3-1 - Stock - B4B	1 pcs	10/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1 pcs	10/29/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	

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21
9-89 NOV 29 2019

DAS
21
9-89 NOV 29 2019

280 QC 21 - FG

1
pcs

10/29/19 0.00 0.00

QC 21 - FG - 21

DAS

QC 21 - FG - 70

21

NOV 29 2019

QC 21 - SA - 53

2-22

Part Op 130 - Skid tubes-1 (Skid tubes) 1-Cut Aft end using DT8185 2-Deburr ends 3-Drill Aft Cap holes using DT8678 *** OPEN
 Descriptions: AFT CAP HOLE TO .187" *** 4-Locate DT 8973 from aft cap holes & Drill Ground wire hole on top of Tube. 5-Install 3/16
 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill. 6-Drill pilot holes for wearplates using DT8900 7-
 Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582. 8-Drill holes for D5520-1 doubler using DT10309 A & B,
 locating from 4th and 5th crossbolt holes from aft using .1875 clekos. Spot drill tube using #20 drill (note 10). Remove
 DT10309 B. Re-install DT 10309 A drill thru tube and doubler using #20 drill (note 10), cleko as you go. Remove .1875
 clekos and open holes in tube and doubler to 0.750". Remove doublers and identify orientation. 9-Deburr doubler and
 doubler holes in skid tube. 10-Countersink doubler holes in skid tube as per Dwg. detail J and note 12 -Touch up alodine
 on D5520-1 doublers. 11- open ground wear holes to 0.391" as per section B-B 12-Open Aft Cap holes using .209" drill.
 13-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65
 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size. 12-Do not open
 holes of section G-G to finishes size.

140 - Skid tubes-1 (Skid tubes) 1-Weld fwd cap D2964 per dwg D3582 and QSI 004 A/R AL ROD
 Batch: 138989/13907 2-Grind flush

150 - QC10 (QC10- Inspect visual per QSI004- ground welds)

160 - QC5 (QC5- Inspect part completeness to step on W/O)

170 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)

180 - QC7-1 (QC7-Inspect Chemical Conversion Coat)

190 - Skid tubes-1 (Skid tubes) ***MASK OFF HOLES OF SECTION F-F (DO NOT C'SINK) 1-Open X-Bolt holes to finish
 size as per Dwg D3582, sections D-D, E-E, G-G as per Dwg. 2-Counter Sink X-BOLT holes as per Dwg D3582 D-D, E-E
 and G-G.***Do NOT countersink holes of section F-F. 3-Deburr and blow out chips from inside of tube, prep. tube for
 welding. 4-Install doublers using DT10309 B. Shave rivets as required. 5-Bond web as per Dwg D3582 & QSI 015 A/R
 241 Sika Flex Batch: 5200625 Exp Date: 07/25/2020 6- Swage x-bolt spacer as per dwg and
 Section F-F QSI002. 7-Weld x-bolt spacers as per Dwg D3582 section D-D, E-E and G-G. A/R AL ROD
 Batch: 138989 8-Grind welds flush

200 - QC10 (QC10- Inspect visual per QSI004- ground welds)

210 - (QC5- Inspect part completeness to step on W/O)

215 - HandFinish2 (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Touch-up alodine as per QSI

220 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME 9:00 OVEN TEMPERATURE:
9:00 FINISH TIME: 11:58

230 - (QC3- Inspect Part Finish)

250 - HandFinish4 (Assemble as per dwg) 1-Inspect for Foreign objects 2-Install Aft cap as per Dwg D3582, Detail "C"
 A/R 241 Sika Flex Batch: 5200623 Exp Date: 20-7-27 3-Install Wearplates as per Dwg D3582 ,
 Note:Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582 *****Do not install
 bolts where indicated on Dwg(Note #6)***** 4- Wing Walk as per Dwg D3582 and QSI 005 4.4

260 - (QC5- Inspect part completeness to step on W/O)

270 - Identify and pack for shipping as per PPP D117-762-041 Location :FG081

275 - (Document Control) Photocopy bluefile & type labels per PPP D117-762-041 CHG003

280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3582-1-BENT	Skidtube Assembly BK117	1 pcs (1 ea)	130-Skidtubes - 1	3221590
D5520-1	Doubler	2 pcs (2 ea)	130-Skidtubes - 1	5218923
D2964	Cap	1 pcs (1 ea)	140-Skidtubes - 2 - B4B	5176506
CR3212-5-05	Rivet	68 pcs (68 ea)	190-Skidtubes - 3 - B4B	3225093
D2971	Cross Bolt Spacer	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	5091024
D3584-1	Web	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	5174779
D3662-1	Crossbolt Spacer	3 pcs (3 ea)	190-Skidtubes - 3 - B4B	3214249
D3662-3	Crossbolt Spacer	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	FB1606
D5304-1	Crossbolt Spacer	2 pcs (2 ea)	190-Skidtubes - 3 - B4B	3216395
ALS4-1032-130	Rivnut	36 Ea (36 ea)	250-Handfinish - 4-1-Assembly-B4B	5209194
ALS4-428-165	Insert	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5147561
AN3-5A	Bolt	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5216385
AN3C4A	Bolt	28 Ea (28 ea)	250-Handfinish - 4-1-Assembly-B4B	5228822
AN4-4A	Bolt	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5193110
D2965	Cap	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5166570
D3508-11	Wearplate Aft Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5172983
D3508-13	Wearplate Aft	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5172981
D3508-3	Wearplate Fwd Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5172576
D3508-9	Wearplate Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5224710
D3558-11	Gasket Aft Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5210684
D3558-13	Gasket Aft	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5210680
D3558-3	Gasket Center Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5210684
D3558-9	Gasket Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5210682
NAS1149C0332R	Washer (AN960C10L)	28 Ea (28 ea)	250-Handfinish - 4-1-Assembly-B4B	5218151
NAS1149D0332J	Washer	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5178378
NAS1149D0416J	Washer	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	FM13151L

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
130-Skidtubes - 1	D3582-1-BENT	1	3	0
	D5520-1	2	42	0
140-Skidtubes - 2 - B4B	D2964	1	22	0
190-Skidtubes - 3 - B4B	CR3212-5-05	68	444	0
	D2971	1	63	0
	D3584-1	1	5	0
	D3662-1	3	119	0
	D3662-3	1	36	0
	D5304-1	2	37	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	36	5,708	0
	ALS4-428-165	2	68	0
	AN3-5A	2	266	0
	AN3C4A	28	1,464	0
	AN4-4A	2	37	0
	D2965	1	50	0
	D3508-11	1	11	0
	D3508-13	1	7	0
	D3508-3	1	14	0
	D3508-9	1	12	0
	D3558-11	1	11	0
	D3558-13	1	3	0
	D3558-3	1	12	0
	D3558-9	1	12	0
	NAS1149C0332R	28	3,974	0
	NAS1149D0332J	2	1,265	0
	NAS1149D0416J	2	1,739	0

Part Specifications

Specifications could not be found.

ITEM	Qty	Part Number	Description
	X	D3882-041	SKIDTUBE ASSEMBLY
1	1	D2982-160	EXTRUSION
2	1	D2884	CAP
3	1	D2885	CAP
4	1	D2971	CROSS BOLT SPACER
5	1	D3508-3	WEARPLATE
6	1	D3508-9	WEARPLATE
7	1	D3508-11	WEARPLATE
8	1	D3508-13	WEARPLATE
9	1	D3558-3	GASKET
10	1	D3558-9	GASKET
11	1	D3558-11	GASKET
12	1	D3558-13	GASKET
13	1	D3884-1	WEB
14	3	D3882-1	CROSS BOLT SPACER
15	1	D3882-3	CROSS BOLT SPACER
16	2	D5304-1	CROSS BOLT SPACER
17	2	D5520-1	DOUBLER
18	28	AN3C4A	BOLT
19	2	AN3-5A	BOLT
20	2	AN4-4A	BOLT
21	28	NAS1148D0332R	WASHER (AN880C10L)
22	2	NAS1148D0332J	WASHER (AN880D10L)
23	2	NAS1148D0416J	WASHER (AN880JD416L)
24	38	AE1S-1032-130	INSERT
25	2	AL57-428-165	INSERT
26	68	GR3212-5-05	CSK RIVET, CHERRY MAX

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 PRIOR TO INSERTING D3884-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 18.2 lbs
 - 8) WELDING: PER DART QSI 004.
 - 9) INSERT D3884-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-2411-281 ADHESIVE PER DART QSI 015 AFTER BENDING.
 - 10) USE DART DRILL TEMPLATE D78800 TO LOCATE AND DRILL Ø0.287 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AE1S-1032-130 PER SECTION G-G (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-2411-281.
 - 11) DO NOT INSTALL ANSC4A BOLTS AND NAS1148D0332R WASHERS IN INDICATED LOCATIONS
 - 12) LOCATE QTY (84) HOLES ONTO THE SKIDTUBE PER D5520-1 DOUBLER AND DRILL Ø0.161 THRU SKIDTUBE AND DOUBLER USING DT10308. COUNTERSINK Ø0.286 x 100° (34 PL) PER DOUBLER AND INSTALL EACH D5520-1 DOUBLER USING QTY (34) CR3212-5-05 CSK RIVETS.

RELEASED
2017-08-11
6217-547

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 701678 M5
19-10-08

E	MOVE VIEWS FROM SHT 1 TO SHT 2. ADD ITEMS 17 & 28 AND NOTE 12.43. Ø0.187 HOLE WAS Ø0.28. ADD SHT 3. ADD DETAIL 1. SECTION F-F ADD D5520-1. SCALE ON VIEWS WAS 3X.	AJS	17.03.27
D	D5304-1 WAS D2972; REVISE BOM & SECTION F-F & SECTION NOTES (ZIN B7-3, A8-3); REF NORT18-6160	RF	17.01.09
C	D3482 PLUG ASSEMBLIES REMOVED. REFORMAT NOTES SHT 1	AP	15.11.02
B	20.88 WAS 23.87 (ZIN C2-1). INCORPORATED DEO D5520-1 (ZIN D5-1). FORMAT TO CURRENT STD	RF	15.02.20
A	NEW ISSUE	PH	07.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	AJS		
CHECKED			
MPG. APPR.	D3582	DRAWING NO.	REV. E
APPROVED		TITLE	SHEET 1 OF 4
DE APPR.		SKIDTUBE ASSEMBLY	SCALE
DATE	17.03.27		NTS

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS			MRB (QSI042)			
Date: _____		Sequence #: _____			QTY Affected: _____			Completed By			
Description Work Order Deviation		Disposition			Lead hand / Supervisor		QC / QA Coordinator				
Root Cause		Operator		Pressure/Forced		Contamination		Power Loss/Surge		Positioned Wrong	
		Manufacturing Process		Bending		Misaligned/off center		Folio/Program		Outside Tolerance	
		Equip/Tooling		Crushing		BOM/Route		Grain Direction		Drawing	
		Handling/Preservation		Cracks		Broken/Damage/Defect		Weld		Finish	
		Material		Crimp/Kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled		Part Lost/Missing	
		Product Improvement		Marks/Chatter		Drill Holes		Out of Sequence		Misread	
		Process Improvement		Mislabeled		Fit/Function		Off-set/Set-up			
		Human Factors		Other/Details:							